

Date: Monday, 2/27/2006 4:17:53 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STRUT
Job Number	25969		
Estimate Number	10272		
P.O. Number	N/A	Part Number	D2562001
This Issue	2/27/2006	S.O. No.	N/A
Prsh Rev.	NC	Drawing Number	D2562 REV D
First Issue	N/A	Project Number	N/A
Previous Run	24272	Drawing Revision	D
Written By	<u>See Comment Below</u>		
Checked & Approved By	<u>KJ 06.02.28</u>		
Comment	Est F 02.04.16 Added dwg Rev.B1 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 1.7920 f(s)/Unit Total : 17.9204 f(s) 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall Batch <u>1119488</u>	 <i>FF 06.04.12</i>
2.0	BRAKE NC	NC BRAKE	 <i>PTO</i>
		Comment: NC BRAKE Punch to length as per Dwg D2562	 <i>FF 06.04.12</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	 <i>10</i>
		Comment: SMALL/MED FAB RESOURCE 1- Bend end as per Dwg D2562 Angle "D" 2-Deburr	 <i>10</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP	 <i>FF 06.04.21</i>
		Comment: INSPECT WORK TO CURRENT STEP	 <i>10</i>
5.0	POWDER COATING	POWDER COATING	 <i>DC 06.04.24</i>
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	 <i>10</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.04.12	2	10 struts one end damaged (good for shorter struts) FT	06.04.12	10				

Part No: D2562-001 PAR #: N/A Fault Category: Prod/FAB. Ass' medtsmt1 NCR: Yes No DQA: Date: 06/04/26
 QA: N/C Closed: Date: 06.04.26

NCR: 2569		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.04.12	2	Piece of Mat'l in strut punch left marks on the struts. Qty of 10 struts. Also dents.	GJ QPM	Use the damaged struts for shorter struts. And replace the Qty of 10. Ensure Punch is free of debris when using.	F.P 06.04.12		B 06.04.12	

NOTE: Date & initial all entries

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Drawing Name: STRUT

Job Number: 25969

Part Number: D2562001

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

1/24/25 (10)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1/26/25 (10)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

1/26/26 (10)

Job Completion



U 01.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

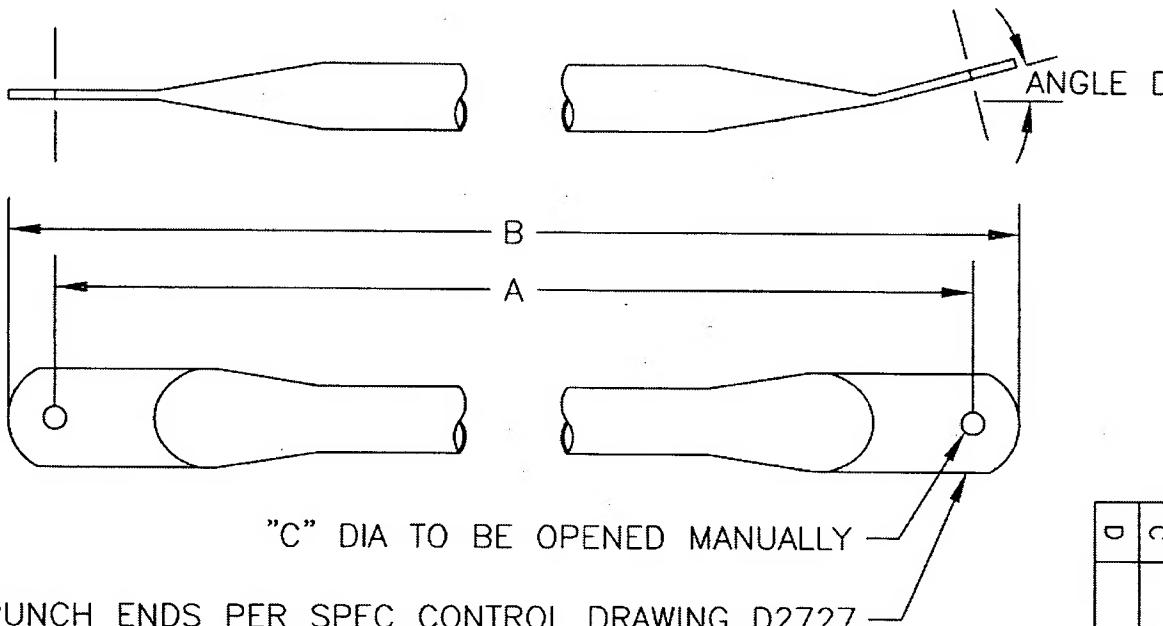
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE			SHEET 1 OF 1
A	96.05.01	NEW ISSUE	
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C	02.06.05	ADD -005; ADD FINISH	
D	05.05.18	ADD -007/-011/-013; UPDATE -005	1.2



PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

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RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 25967

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES